Rush

D2565-111
B99752

Work Order ID 99752 *99752*

November-22-13 7:12:05 AM

Item ID: D2565-111

Revision ID:

Item Name: Strut

10

Start Date: 4/11/13 **Start Qty:** 6.00 *6*

Required Date: 4/11/13 **Req'd Qty:** 6.00 *6*

Reference:

Accept *N900040100*

Setup Start *NS1* **Stop** *NS2*

Cust Item ID:

Customer:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2565	**Revision Nbr** Rev E								
100 *100* Brake NC	Punch ends and deburr as per dwg NC BRAKE	0.00		30 9-89		10			13/11/25
Brake NC	**Memo** Punch as per Dwg D2565 using DT 8313	0.00							
110 *110* Small Fab	Small Fab	0.00				10			13/11/26 DAS 36 9-89
Small Fab	**Memo** Deburr	0.00							
120 *120* QC	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89 13/11/26				10			
Quality Control	**Memo**	0.00							

Work Order ID 99752 *99752*

November-22-13 7:12:05 AM

Item ID: D2565-111 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Strut

Start Date: 4/11/13 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 4/11/13 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M126839.	0.00				10	ø	13-11-26.	DAS 34 9-89
	Memo START TIME: 1:55 OVEN TEMPERATURE: 400° FINISH TIME: 2:25.	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00	DAS 27 9-89 13/11/26			10			
	Memo	0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST252,	0.00				10X			13-11-28
	Memo	0.00							

DAS 26 9-89

Work Order ID 99752 *99752*

November-22-13 7:12:05 AM

Item ID: D2565-111 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 4/11/13 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 4/11/13 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00							RM 13/11/27
QC Quality Control	**Memo**	0.00							

13-11-27

Picklist Print

November-22-13 7:12:04 AM

Work Order ID: 99752

Parent Item: D2565-111 **Start Date:** 4/11/13 **Required Date:** 4/11/13

Parent Item Name: Strut **Start Qty:** 6.00 **Required Qty:** 6.00

Comments: IPP: E01.06.04Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC
IPP: E06.05.03 Change level 2/8 to QC5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	337.8490	**1.1375**	**7.1842104**	DAS 30 9-89	13\11\25	

Location	Loc Qty	Loc Code	
MAT017	337.849018		
122312	10.8		
124768	55.31245		
M126183	238.620001		3 8.5
M126349	33.116567		2 4.5 12.5

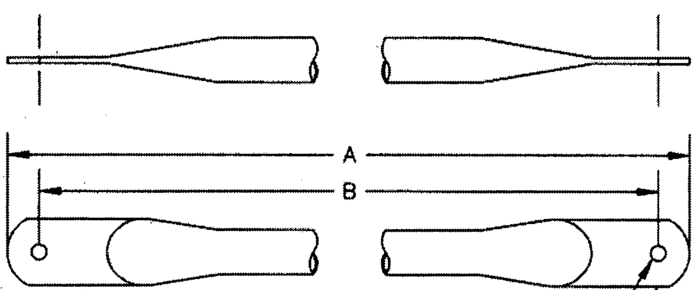
DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2565 — REV. E — SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT — SCALE 1:3

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

RELEASED 04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

4/09752

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES
1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
   (REF DART SPEC. M304TR0.750W0.049)
   ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD

DART AEROSPACE

Description: Strut		Work Order: 99752
Inspection Drawing: D2565	Rev: E	Part Number: D 2565-111

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.65	+/-.030	13.65	✓		T	SD-05
12.85	+/-.030	12.85	✓		T	SD-05
0.257	+/-.005	0.257	✓		U	SD-05

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
Date 13/11/25	Date 13/11/25	Date 13/11/25	Date